Work Order ID 88242 *88242* Page 1

July-31-12 12:42:57 PM

Item ID: D3847-045 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: CENTER WEARPLATE ASSY, STD/FLOAT

Start Date: 7/24/12 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 8/31/12 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 12/08/02 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
100						4	0		JM 12-8-10
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3847 Dwg Rev: B Prog Rev: B								
304.050	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						4	0		JM 12-8-10
QC	**Memo**	0.00							
Quality Control									

Draw Nbr	Revision Nbr
D3847	B

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Item ID: D3847-045 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: CENTER WEARPLATE ASSY, STD/FLOAT

Start Date: 7/24/12 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 8/31/12 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 SmB 12.8.13 0.00	DAS 16 8-89 11/06/13			4			
130 *130* Brake NC Brake NC	**Memo** form as per dwg D3847	0.00 0.00				4			SA 12/02/13
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 SmB 12.8.13	DAS 16 8-89 12/02/13			4			

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Item ID: D3847-045 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: CENTER WEARPLATE ASSY, STD/FLOAT

Start Date: 7/24/12 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 8/31/12 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00 Start Time: 1:50				4X Ø			MF 12/8/13
150 Powdercoat	**Memo**	0.00 Temp = 320°F							
Powder Coating	M121274	Finish Time: 2:20							
160	QC3- Inspect Part Finish	0.00							
160 QC	**Memo**	0.00				4 x ✓			M 11/08/15
Quality Control									
170		0.00							
170 Small Fab	**Memo**	0.00				4 Ø			AE 12.08.15
Small Fab	1- Bond gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg D3847								
	BATCH: M122306								

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Turning Sequence
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General

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- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Item ID: D3847-045 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: CENTER WEARPLATE ASSY, STD/FLOAT

Start Date: 7/24/12 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 8/31/12 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180 QC Quality Control	Memo	0.00							
190	Identify as per dwg & Stock Location: FP	0.00							
190 Packaging Packaging	Memo	0.00							
200	QC21- Final Inspection - Work Order Release	0.00							
200 QC Quality Control	Memo	0.00							

DAS 16 9-89 12/05/15

12/08/16

MLJ 12/08/16

MLJ 12/08/16

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
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☐ Grain
☐ Hardware
☐ Inspection Incomplete
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☐ Maintenance
☐ Mislabeled
☐ Misread
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☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Picklist Print

July-31-12 12:42:57 PM

Work Order ID: 88242

Parent Item: D3847-045 **Start Date:** 7/24/12 **Required Date:** 8/31/12

Parent Item Name: CENTER WEARPLATE ASSY, STD/FLOAT **Start Qty:** 4.00 **Required Qty:** 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hard	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3846-5 GASKET		Manufactured	No				Each	4.0000		4	4	12.08.15	
				Location		**Loc Qty**		**Loc Code**					
				FP002		4							
					52678	4							
M304S18GA 304/316 .050 Sheet		Purchased	No				sf	342.4649		~~0.408842~~ 0.5		JM 12-8-12	
				Location		**Loc Qty**		**Loc Code**					
				MAT020		342.464947							
					120604	8.66421							
					121626	2.65							
					121660	27.000737							
					122325	304.15							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Crosstube ☐
- Water Jet ☐
- Engineering ☐
- Machining ☐
- Small Fab ☐
- Prod. Eng. Coor. ☐
- Quality ☐
- Thermoforming ☐
- Finishing ☐
- Rec/Store/Packaging ☐
- Other ☐
- Large Fab ☐
- Composite ☐
- Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
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- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
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- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

DART AEROSPACE LTD	Work Order:	88242
Description: Plate	Part Number:	D3847-5
Inspection Dwg: D3847 Rev: B		Page 1 of 1

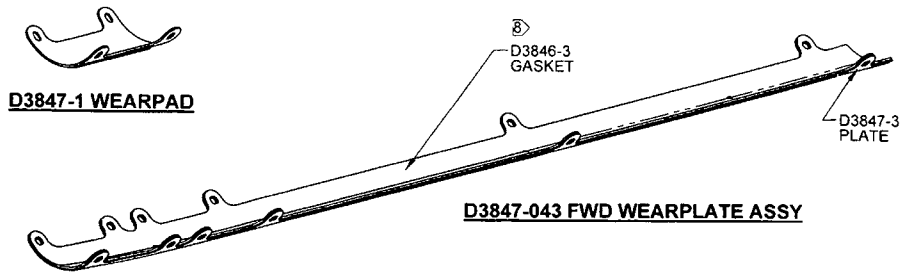
FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.188"	–		V	MMO1
0.300	+/-0.010	0.301"	–		V	
0.300	+/-0.010	0.302"	–		V	
3.280	+/-0.010	3.280"	–		V	
2.45	+/-0.030	2.457"	–		V	
4.13	+/-0.030	4.137"	–		V	
1.69	+/-0.030	1.697"	–		V	
8.49	+/-0.030	8.496"	–		V	Producer
18.000	+/-0.010	18.000"	–		T	HBD1
34.98	+/-0.030	34.99"	–		T	
0.75	+/-0.030	0.762"	–		V	
15.803	+/-0.010	15.803"	–		T	
31.606	+/-0.010	31.606"	–		T	
0.050	+/-0.010	0.047"	–		V	

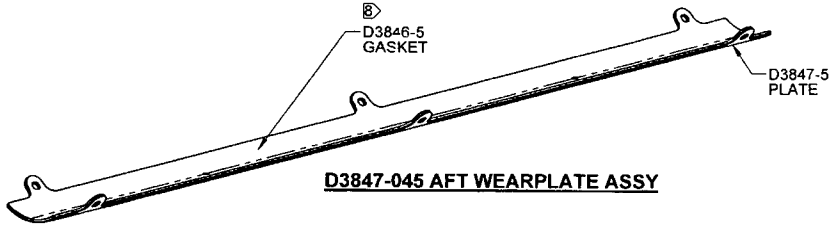
Measured by:	JM	Audited by:	SMB (DAS)	Prototype Approval:	N/A
Date:	12-8-10	Date:	12-8-10 16	12/08/13 Date:	N/A

Rev	Date	Change		Revised by	Approved
A	09.09.28	New Issue	P/O D3847-045	KJ	

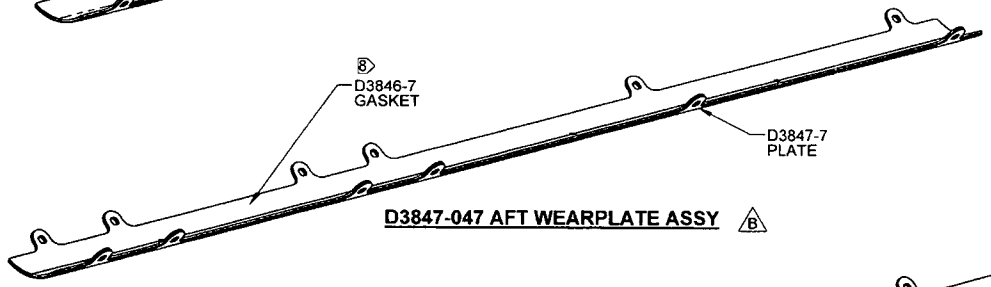


D3847-1 WEARPAD

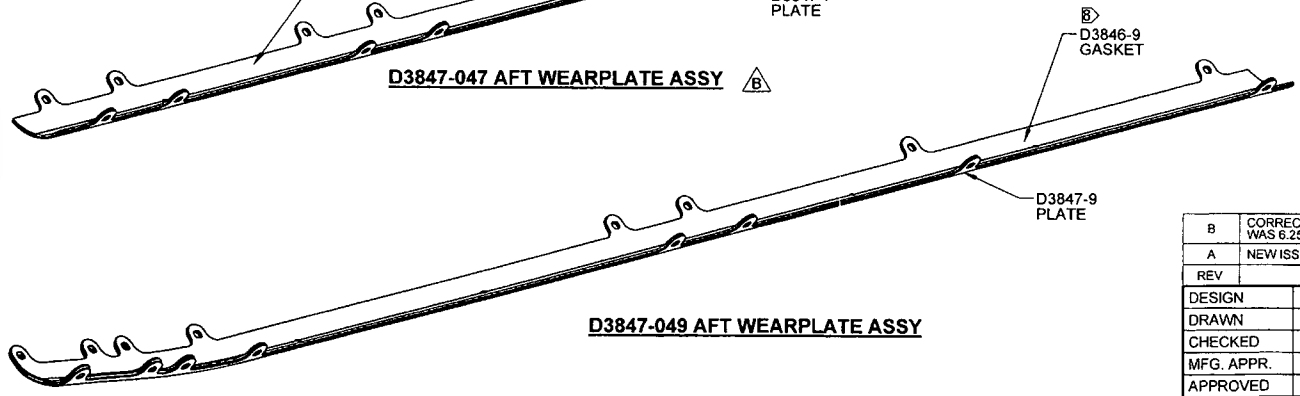
D3847-043 FWD WEARPLATE ASSY



D3847-045 AFT WEARPLATE ASSY



D3847-047 AFT WEARPLATE ASSY (B)



D3847-049 AFT WEARPLATE ASSY

ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043 ✓	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045 ✓	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047 ✓	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049 ✓	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
15	1				D3846-3	GASKET
16		1			D3846-5	GASKET
17			1		D3846-7	GASKET
18				1	D3846-9	GASKET
31	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE
7) WEIGHT D3847-043 = 1.71 lbs
D3847-045 = 1.49 lbs
D3847-047 = 2.00 lbs
D3847-049 = 4.21 lbs
8) BOND D3846-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

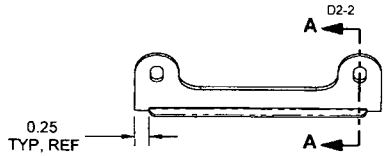
D3847-11 WEARPAD

RELEASED 09/07/15 MM

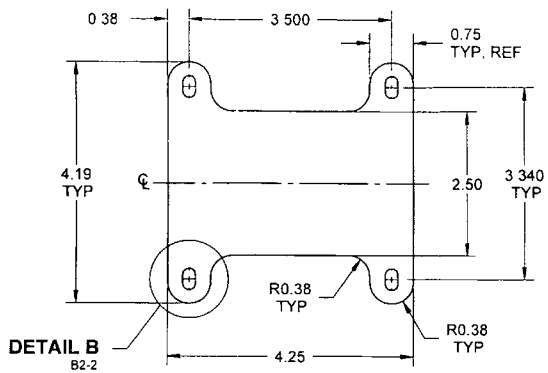
REV	DESCRIPTION	BY	DATE
B	CORRECT TYPO D3847-047 WAS D3847-045 ZN B5-1; 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RH	DRAWING NO. D3847	REV. B
MFG. APPR.			SHEET 1 OF 7
APPROVED	MM	TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.			
DATE	09.06.30		

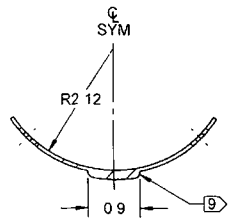
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 88242 MLJ
12/08/02



D3847-1 WEARPAD
MADE FROM D3847-1F FLAT PATTERN

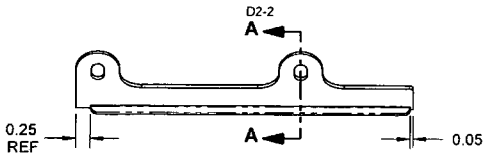


D3847-1F FLAT PATTERN

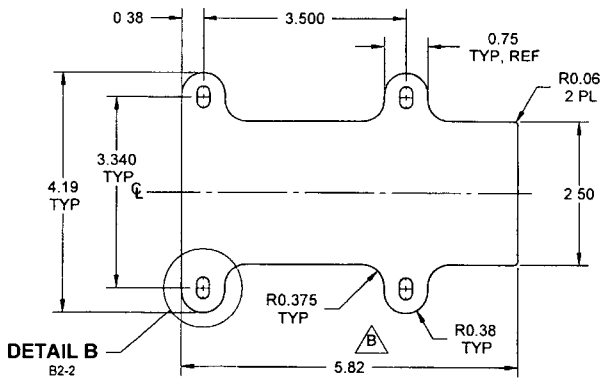


SECTION A-A D7-2 B7-2

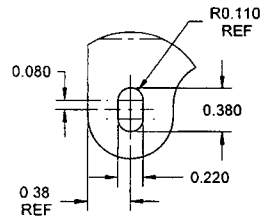
88242



D3847-11 WEARPAD
MADE FROM D3847-11F FLAT PATTERN



D3847-11F FLAT PATTERN



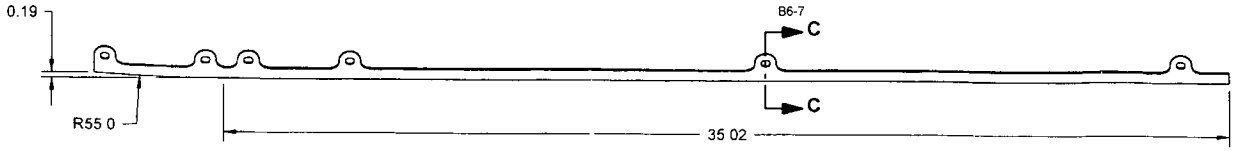
DETAIL B C5-2 B5-2
TYP, SCALE 2X

RELEASED
09/07/15 MB

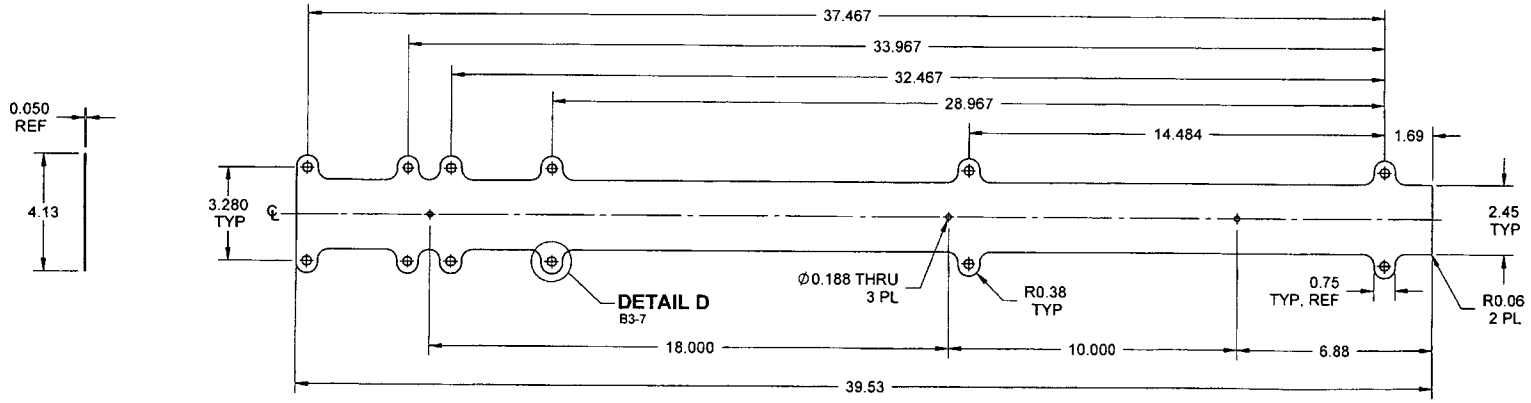
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT:
   D3847-1 = 0 03 lbs
   D3847-11 = 0.47 lbs
8) WELD PER QSI 004
9) APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0 25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3847	REV. B
MFG. APPR.			SHEET 2 OF 7
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.			
DATE	09.06.30		

88242



D3847-3 PLATE
MADE FROM D3847-3F FLAT PATTERN



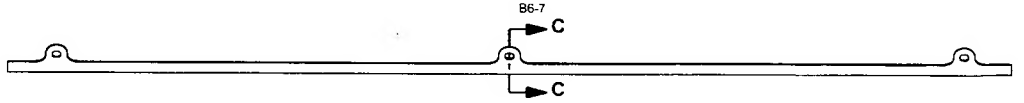
D3847-3F FLAT PATTERN

RELEASED
6/10/2010

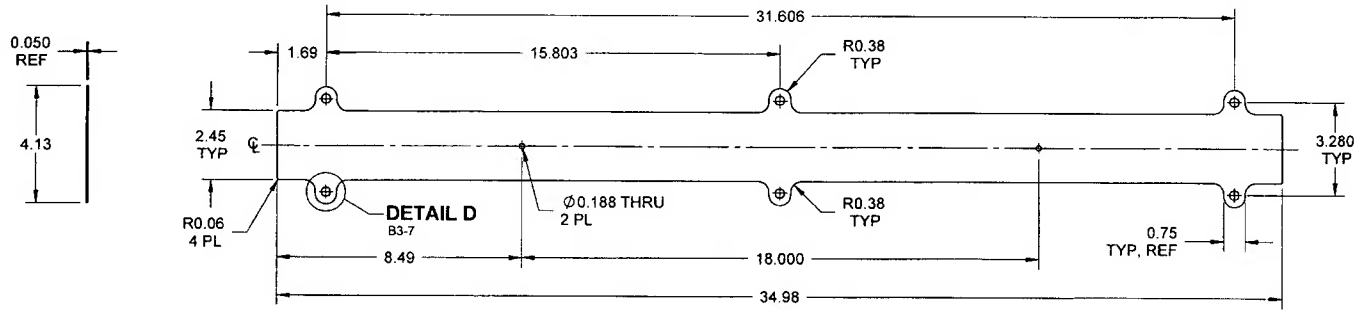
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5 6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.46 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	RF	
CHECKED		DRAWING NO. D3847 REV. B
MFG. APPR.		SHEET 3 OF 7
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	09.06.30	

88242



D3847-5 PLATE
MADE FROM D3847-5F FLAT PATTERN

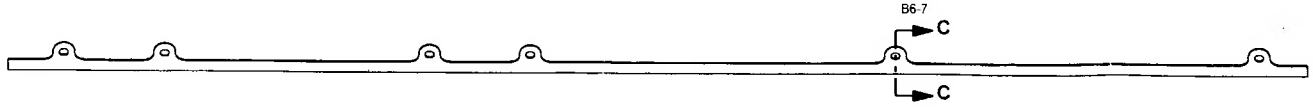


D3847-5F FLAT PATTERN

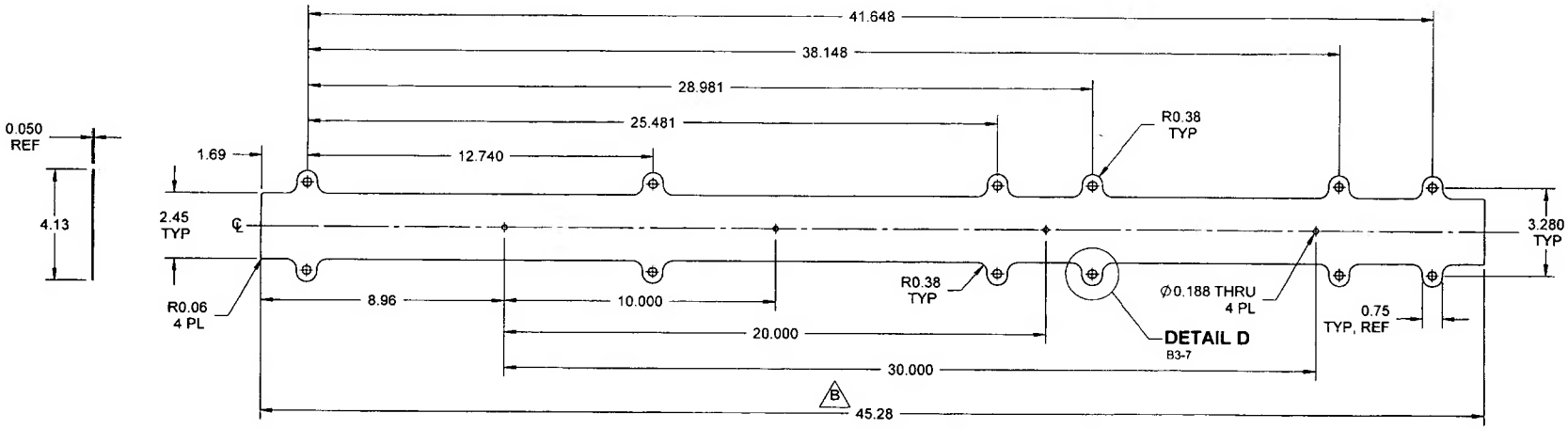
RELEASED
09/07/15 MH

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.29 lbs

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED	RF	DRAWING NO. D3847 REV. B
MFG. APPR.		SHEET 4 OF 7
APPROVED	AM	TITLE WEARPLATE ASSY
DE APPR.		SCALE NTS
DATE	09.06.30	



D3847-7 PLATE
MADE FROM D3847-7F FLAT PATTERN



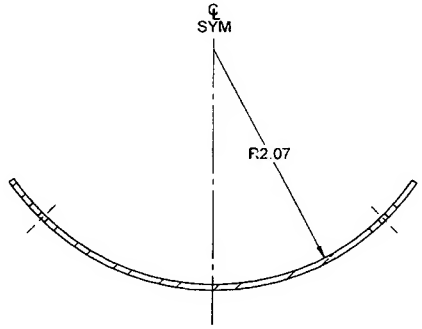
D3847-7F FLAT PATTERN

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.70 lbs

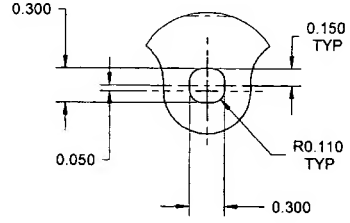
RELEASED 09/07/10 MD

DESIGN	RF	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	RF	
CHECKED	RH	DRAWING NO. D3847 REV. B
MFG. APPR.		SHEET 5 OF 7
APPROVED	MD	TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	09.06.30	

8242



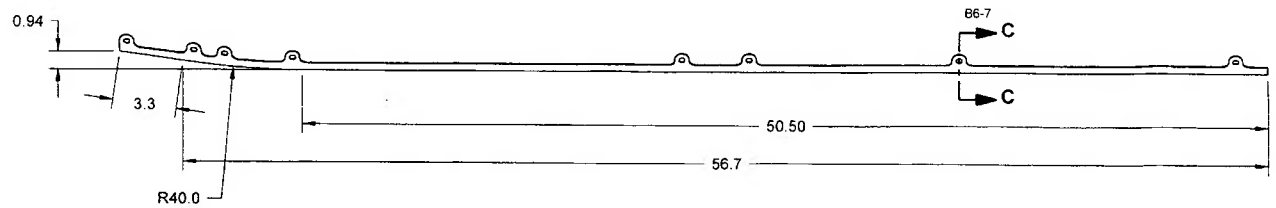
SECTION C-C D4-3 D4-4 D3-5 D3-6
SCALE 4X



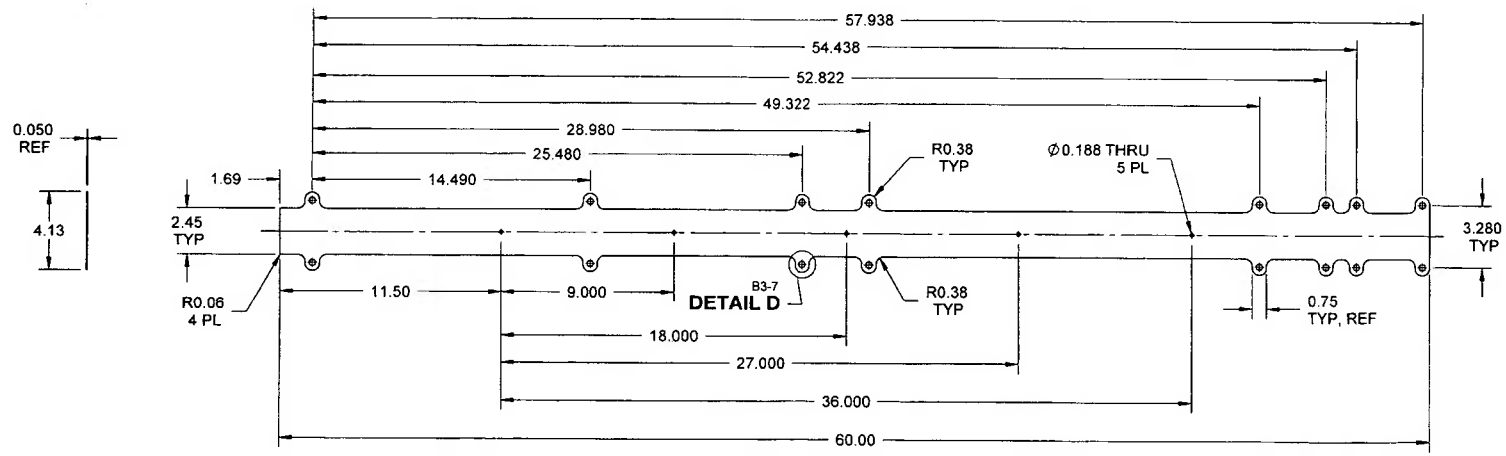
DETAIL D B5-3 B6-4 B3-5 B5-6
TYP, SCALE 4X

RELEASED
09/07/15 MD

DESIGN	RF	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D3847	REV. B
MFG. APPR.			SHEET 7 OF 7
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.			
DATE 09.06.30			



D3847-9 PLATE
MADE FROM D3847-9F FLAT PATTERN



D3847-9F FLAT PATTERN

RELEASED 09/07/15

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 3.86 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	RF	
CHECKED	AB	DRAWING NO. D3847 REV. B
MFG. APPR.	E	SHEET 6 OF 7
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	09.06.30	